

High Feed Milling

- Plated Cutter Bodies
- Resistance against
 - chip erosion
 - corrosion



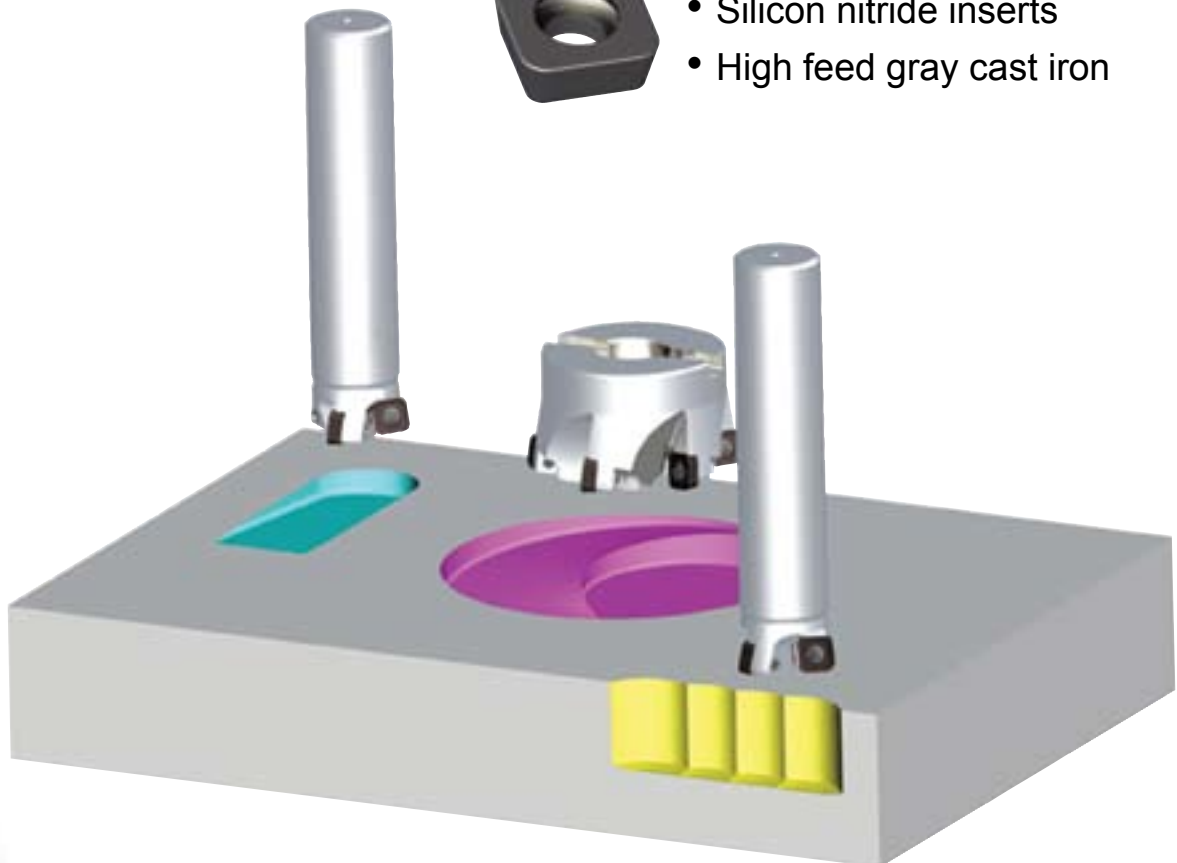
- Ramping
- Plunging
- Circle Interpolate
- Enlarge



- Coated carbide inserts
- Most materials

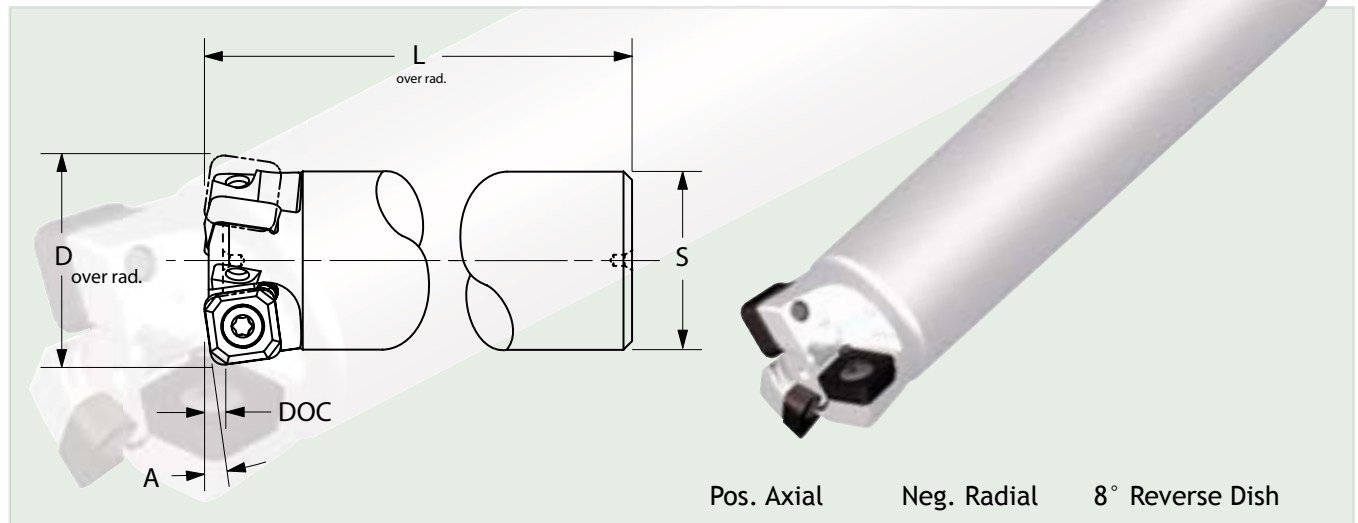
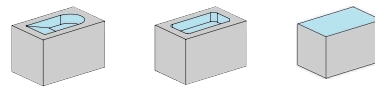


- Silicon nitride inserts
- High feed gray cast iron



Positive End Mills

250 Series

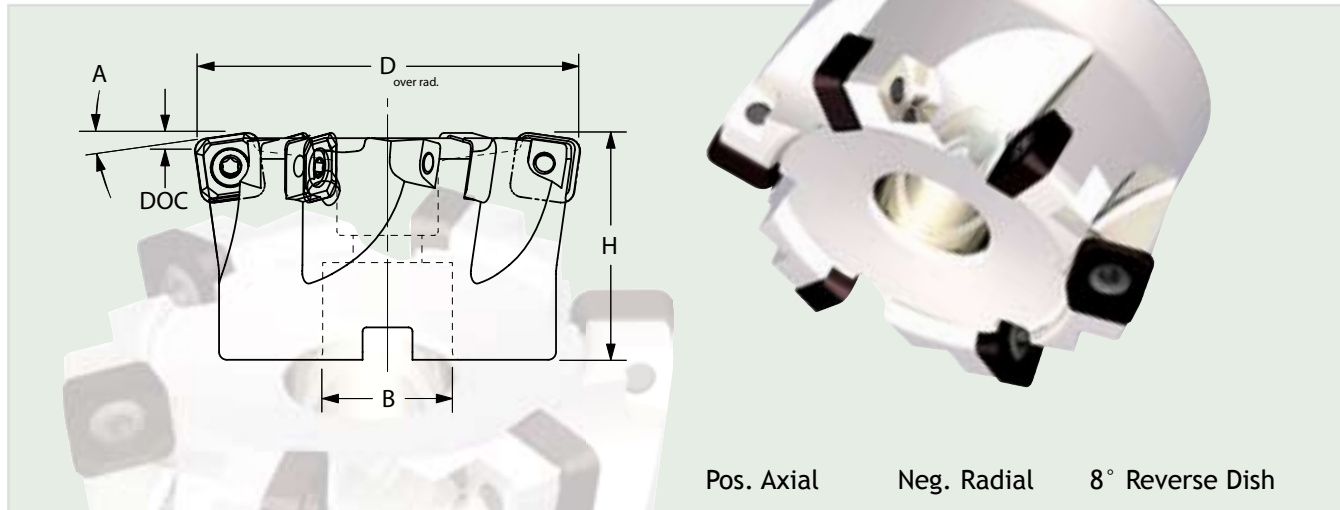
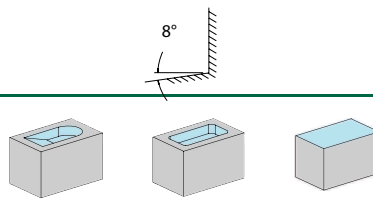


250 Series End Mill - Dimensional Specifications								
Product Number	D	S	L	A	DOC	Insert	Screw	Teeth
250E0125ASP4-S100R	1.250	1.000	6.00	8°	.040	SPEX-436	3605-0001-0023	2
						SPCW-436W820	3605-0001-0067	
250E0150ASP4-S125R	1.500	1.250	6.00	8°	.040	SPEX-436	3605-0001-0023	3
						SPCW-436W820	3605-0001-0067	

Accessory Parts					
Insert IC x Thickness					
	Insert see page 41	Insert see page 41	Torx Screw for SPEX inserts	Torx Screw for SPCW inserts	Wrench
.500 x .220	SPEX-436	SPCW-436W820	3605-0001-0023	3605-0001-0067	1557-TX20

Positive Face Mills





250 Series



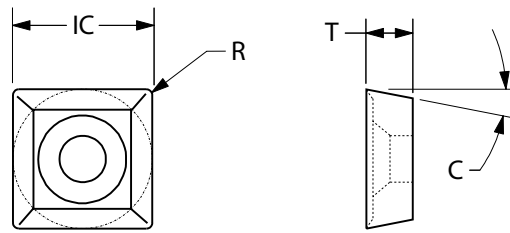
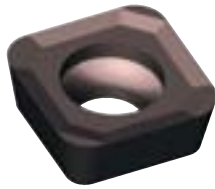
250 Series Face Mill - Dimensional Specifications

Product Number	D	B	H	A	DOC	Insert	Screw	Teeth
250F0200ASP4-075R	2.000	0.750	1.56	8°	.040	SPEX-436	3605-0001-0023	4
						SPCW-436W820	3605-0001-0067	
250F0300ASP4-100R	3.000	1.000	1.75	8°	.040	SPEX-436	3605-0001-0023	6
						SPCW-436W820	3605-0001-0067	
250F0400ASP4-150R	4.000	1.500	2.00	8°	.040	SPEX-436	3605-0001-0023	7
						SPCW-436W820	3605-0001-0067	

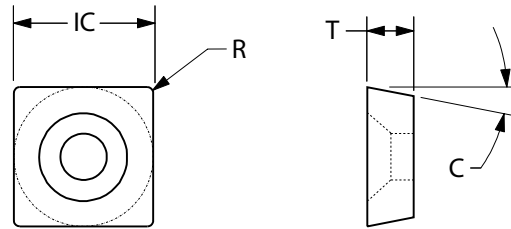
Accessory Parts

Insert IC x Thickness					
	Insert see page 41	Insert see page 41	Torx Screw for SPEX inserts	Torx Screw for SPCW inserts	Wrench
.500 x .220	SPEX-436	SPCW-436W820	3605-0001-0023	3605-0001-0067	1557-TX20

250 Series



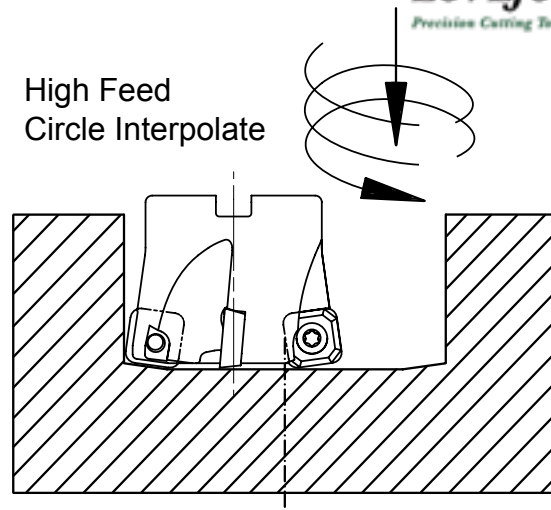
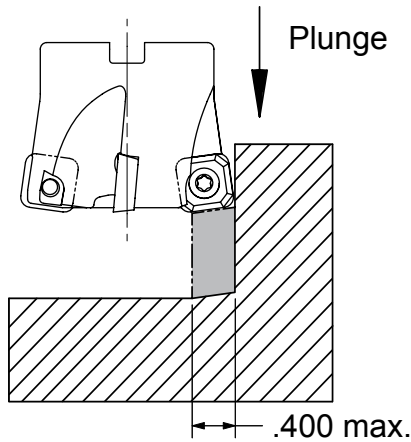
Insert Dimensional & Grade Specifications									
Insert Number	IC	T	R	C	LT-4073B	LT-2373B	908XRm	LTC-1200	
SPEX-436	0.500	0.188	0.094	11°	●	■	●	●	



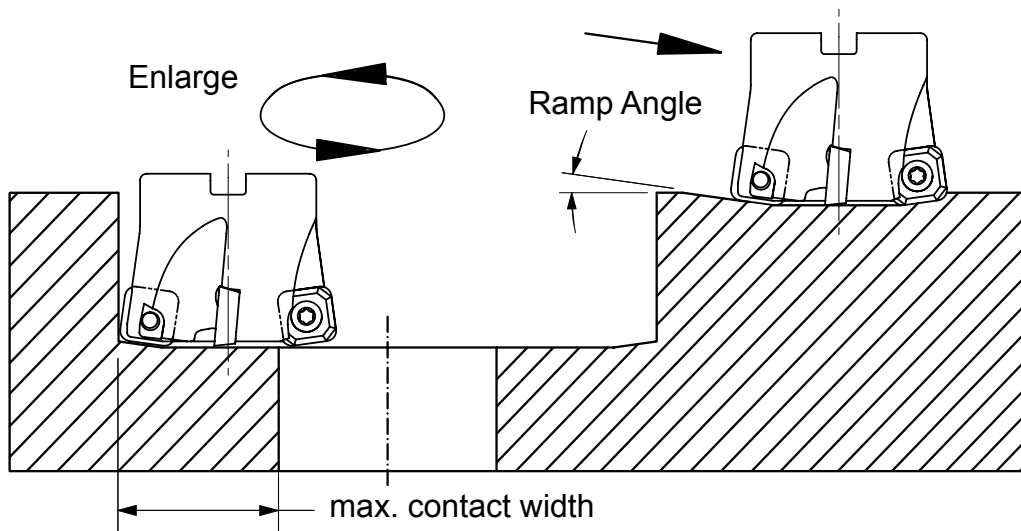
Insert Dimensional & Grade Specifications									
Insert Number	IC	T	R	C	LT-4073B	LT-2373B	908XRm	LTC-1200	
SPCW-436W820	0.500	0.188	0.094	11°				▼	

250 Series High Feed Cutter - Speeds and Feeds Machining Parameters				
Material	SFM	Feed / Tooth	Max. D.O.C.	Insert
Low Carbon Steel	650 - 750	.020 - .060	0.040	SPEX-436 GR LT-4073B
Alloy Steel	500 - 600	.020 - .060	0.040	SPEX-436 GR LT-4073B
Austenitic Stainless	550 - 650	.020 - .060	0.040	SPEX-436 GR LT-2373B
Martensitic Stainless	500 - 550	.020 - .060	0.040	SPEX-436 GR LT-2373B
Aluminum	1000 +	.020 - .060	0.040	SPEX-436 GR 908XRm
▼ Gray Cast Iron	2500 - 2800	.020 - .060	0.040	SPCW-436W820 LTC-1200
■ Gray & Ductile Iron	750 - 850	.020 - .060	0.040	SPEX-436 GR LT-2373B
Titanium / Supper Alloys	80 - 150	.020 - .060	0.040	SPEX-436 GR 908XRm

P = Steel
 M = Stainless
 K = Cast Iron
 N = Non-Ferrous
 S = High Temp Alloy



250 Series - Min. Max. Bores for Circle Interpolation				
Tool Dia.	Min. Bore	Max. Bore	Ramp Depth	Ramp Angle
1.25	1.470	2.338	0.040	6°
1.50	1.720	2.838	0.040	3° 30'
2.00	2.220	3.838	0.040	2°
3.00	3.220	5.838	0.040	1°
4.00	4.220	7.838	0.040	0° 30'



250 Series - Parameters			
Tool Dia.	Contact Width	Ramp Depth	Ramp Angle
1.25	0.840	0.040	6°
1.50	1.090	0.040	3° 30'
2.00	1.590	0.040	2°
3.00	2.590	0.040	1°
4.00	3.590	0.040	0° 30'



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